

Work Order ID 67920

Page 1

Monday, April 04, 2011 3:58:32 PM

Item ID: D4032-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Assembly (350)

Start Date: 4/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

ME

Date:

11-04-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4032	D								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
HandFinish	Memo	0.00							
Hand Finishing	****Mask label plate to size of D4086 label, use scotchbrite red pad to lightly sand area for label, apply label ****								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

*Ca/4/19 D**EB 4/04/20 @**HL*

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Item ID: D4032-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Short Basket Assembly (350)

Start Date: 4/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/22/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

PP 67919

11/4/20



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

11/4/20



QC

Memo

0.00

Quality Control

mf

11-04-20

Picklist Print

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Page 1

Work Order ID: 67920

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)



Start Date: 4/11/2011

Required Date: 4/22/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.12.02 verified by:EC IPP Rev:B as per PA3 DD 10.03.10 verified by:EC IPP Rev:C as per RevA DD 10.03.23 verified by:EC IPP Rev:D as per dwg revC DD 10.04.20 verified by:EC IPP Rev:E as per dwg revD DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4086-232 Placard, Max Load		Manufactured	No			100	Each	8.0000	1	1	✓		
<div> <div>Location</div> <div>ST122</div> <div>66274</div> </div> <div> <div>Loc Qty</div> <div>8</div> <div>8</div> </div> <div> <div>Loc Code</div> <div></div> <div>66274</div> </div>													
D2530 Handle Weldment		Manufactured	No			100	Each	13.0000	1	1	✓		
<div> <div>Location</div> <div>ST506</div> <div>66171</div> <div>66563</div> </div> <div> <div>Loc Qty</div> <div>13</div> <div>5</div> <div>8</div> </div> <div> <div>Loc Code</div> <div></div> <div>66171</div> <div></div> </div>													
D2535 Spring		Manufactured	No			100	Each	65.0000	2	2	✓		
<div> <div>Location</div> <div>ST504</div> <div>64280</div> <div>66764</div> </div> <div> <div>Loc Qty</div> <div>65</div> <div>11</div> <div>54</div> </div> <div> <div>Loc Code</div> <div></div> <div>64280</div> <div></div> </div>													

JB

JB

JB 11/04/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 67920

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 4/11/2011

Required Date: 4/22/2011

Start Qty: 1.00

Required Qty: 1.00

D2537

Manufactured No

100 Each

58.0000

2

2

✓



Bushing

Location

Loc Qty

Loc Code

ST504

58

65077

16

66972

42

65077

D3917-3

Manufactured No

100 Each

20.0000

6

6

✓



Washer

Location

Loc Qty

Loc Code

ST092

20

66903

20

67780

D3953-3

Manufactured No

100 Each

0.0000

2

2

✓



Gas Spring Stud, Lid

D3953-7

Manufactured No

100 Each

7.0000

2

2

✓



Spring Spacer

Location

Loc Qty

Loc Code

ST096

7

65053

4

65621

3

68230

D3953-9

Manufactured No

100 Each

16.0000

2

2

✓



Gas Spring Washer

Location

Loc Qty

Loc Code

ST089

16

66162

16

68231

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 67920

Parent Item: D4032-041











Parent Item Name: Short Basket Assembly (350)

Start Date: 4/11/2011

Required Date: 4/22/2011

Start Qty: 1.00

Required Qty: 1.00

D3953-17	Manufactured	No	100	Each	8.0000	2	2	✓	
									JB 67968 E
Gas Spring Spacer									
			<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>	
			ST096			8			
			65138			8			
D3953-19	Manufactured	No	100	Each	9.0000	1	1	✓	
									JB
Gas Spring Bracket									
			<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>	
			ST096			9			
			59213			1			
			64810			8			
D3953-21	Manufactured	No	100	Each	8.0000	1	1	✓	
									JB 11/04/19
Gas Spring Bracket									
			<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>	
			ST096			8			
			66110			8			
D3969-3	Manufactured	No	100	Each	4.0000	1	1	✓	
									JB 11/04/20
Spring (Basket Lid)									
			<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>	
			ST272			4			
			64285			4			
D4017-041	Manufactured	No	100	Each	0.0000	1	1	✓	
									B68653 (u)
Short Basket Base Assembly (350)									
									B67924
									JB 11/04/19

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 67920

Parent Item: D4032-041


Parent Item Name: Short Basket Assembly (350)


Start Date: 4/11/2011

Required Date: 4/22/2011


Start Qty: 1.00

Required Qty: 1.00

AN310-4 Purchased No 100 Each 28.0000 3 3 ✓

 NUT


 117442 JB ✓


Location	Loc Qty	Loc Code
ST324	28	
116786	28	

AN310C4 Purchased No 100 Each 34.0000 2 2 ✓

 Nut


 JB ✓

Location	Loc Qty	Loc Code
ST324	34	
116741	34	

MS21042L3 Purchased No 100 Each 2,074.000 6 6 ✓

 Nut


 116741 JB ✓

Location	Loc Qty	Loc Code
ST300	2074	
116391	474	
116540	800	
116549	800	

MS21042L5 Purchased No 100 Each 861.0000 4 4 ✓

 Nut

 116391 JB 11/04/19

Location	Loc Qty	Loc Code
ST300	861	
115594	101	
116105	500	
116548	260	

 116105

Picklist Print

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Work Order ID: 67920

Parent Item: D4032-041

Parent Item Name: Short Basket Assembly (350)

Start Date: 4/11/2011

Required Date: 4/22/2011

Start Qty: 1.00

Required Qty: 1.00

MS24665-151

Purchased

No

100

Each

517.0000

3

3

✓



Cotter Pin

Location

Loc Qty

Loc Code

ST309

517

17566

517

100

Each

98.0000

2

2

✓

MS24665-300

Purchased

No



Cotter Pin

Location

Loc Qty

Loc Code

ST309

98

116823

98

100

Each

0.0000

6

6

NAS1149F0432P

Purchased

No



Washer

NAS1149C0432R

Purchased

No

100

Each

1,614.000

2

2

✓



Washer

Location

Loc Qty

Loc Code

ST297

1614

116900

1614

100

Each

22.0000

8

8

✓

NAS1149F0332P

Purchased

No



WASHER

Location

Loc Qty

Loc Code

ST275

22

18057

22

11/04/9

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Shop Packet Print

Page 6

Picklist Print

Page 7

Monday, April 04, 2011 3:58:28 PM

Work Order ID: 67920



Parent Item: D4032-041



Parent Item Name: Short Basket Assembly (350)

Start Date: 4/11/2011

Required Date: 4/22/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0563P

Purchased

No

100

Each

89.0000

4

4 ✓



Washer

J B
4/11/04/11

Location

Loc Qty

Loc Code

ST275

89

114576

89

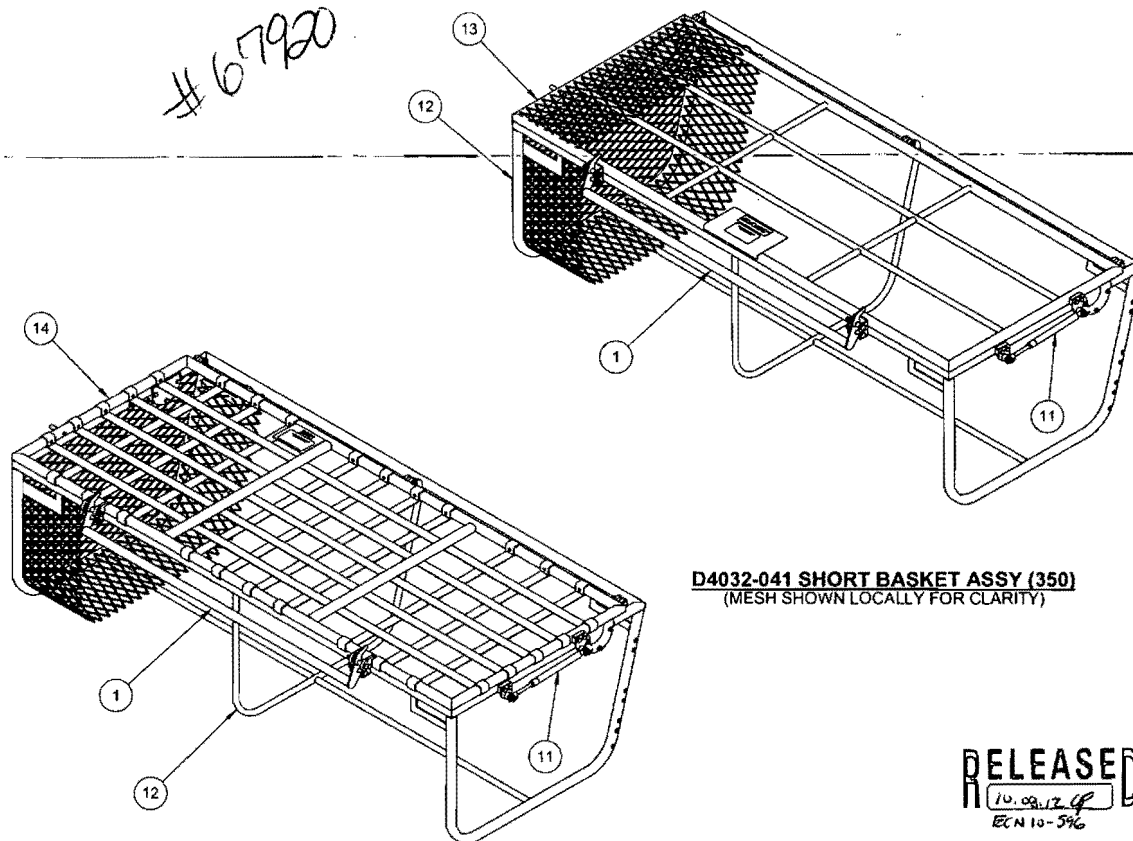
114576

Monday, April 04, 2011 3:58:28 PM

Shop Packet Print

Page 7

ITEM	-041 QTY.	-043 QTY.	P/N	DESCRIPTION
	X		D4032-041	SHORT BASKET ASSY (350)
		X	D4032-043	SHORT BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	2	2	D2537	BUSHING
4	6	6	D3917-3	WASHER
5	2	2	D3953-3	GAS SPRING STUD, LID
6	2	2	D3953-7	GAS SPRING SPACER
7	2	2	D3953-9	GAS SPRING WASHER
8	2	2	D3953-17	GAS SPRING SPACER
9	1	1	D3953-19	GAS SPRING BRACKET
10	1	1	D3953-21	GAS SPRING BRACKET
11	1	1	D3969-3	SPRING
12	1	1	D4017-041	SHORT BASKET BASE ASSY (350)
13	1		D4018-041	SHORT BASKET LID ASSY (350)
14		1	D4019-041	LIGHT LID SHORT BASKET ASSY
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	2	2	NAS1149C0432R	WASHER
29	8	8	NAS1149F0332P	WASHER
30	4	4	NAS1149F0563P	WASHER



D4032-041 SHORT BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12
ECN 10-596

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: -041: 56 lbs APPROX
-043: 45 lbs APPROX

D	QTY FOR ITEMS #28, #29 & #30 UNDER -043 WERE MISSING (B8-1); QTY FOR ITEM #3 WAS 4 (D6-1), ONLY 2 ARE REQUIRED, AFFECTS SECTION C-C (D3-3)	MB	10.07.23
C	AN5-21A BOLT WAS AN5-19A BOLT: BOM & (D3-3)	JPH	10.04.06
B	ITEM 15 D4086-232 & 16 D4086-243 REMOVED; ITEM RENUMBERED AS REQD. PLACARDS REMOVED (C6-2); TOP VIEW DETAIL REMOVED (C2-2)	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	AS		
DRAWN	JP		
CHECKED	JP		
MFG. APPR.	JFS		
APPROVED	AD		
DE APPR.	CH		
DATE	10.07.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4032 TITLE SHORT BASKET ASSY (350) SCALE NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

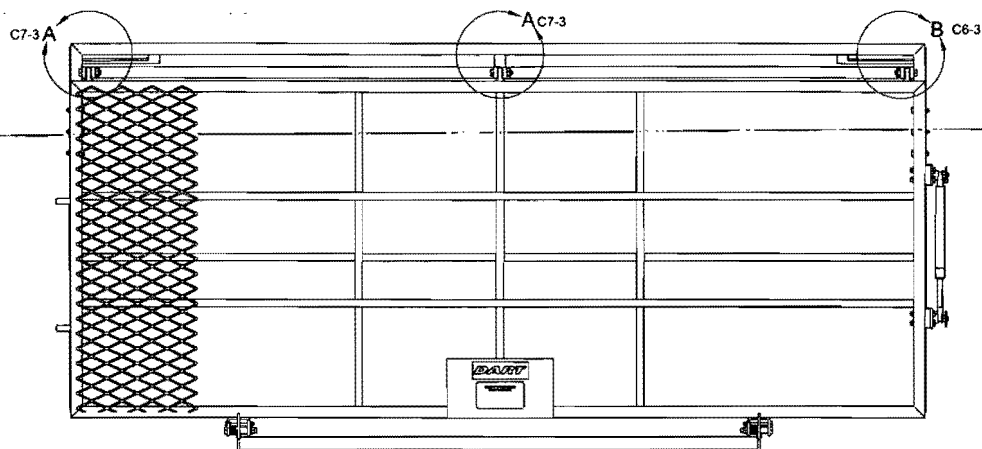
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

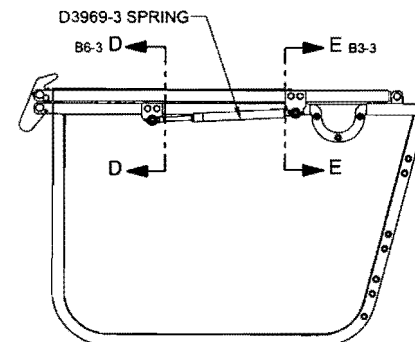
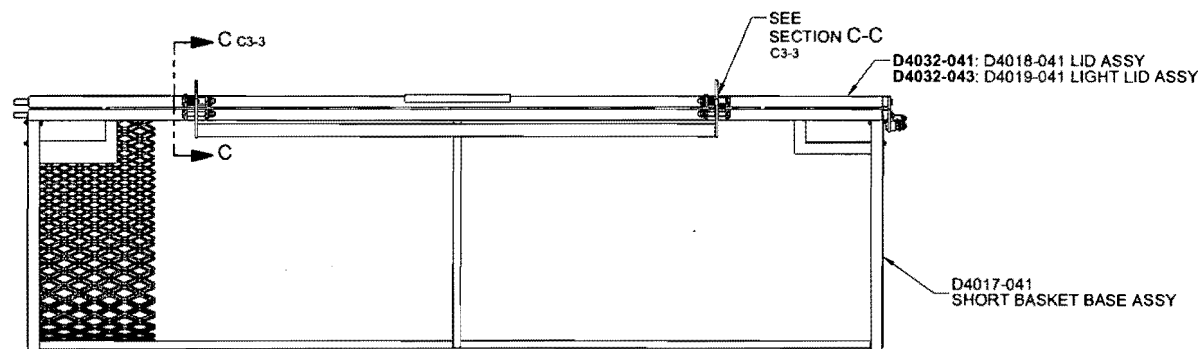
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



#67920



D4032-041 SHORT BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)
D4032-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.17

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.	J.F.S. G.L.A.	D4032	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMBINED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

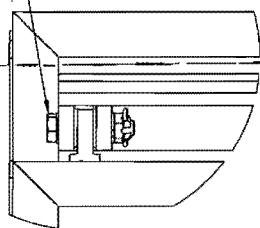
4

3

2

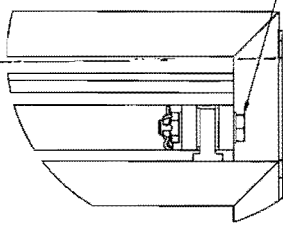
1

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



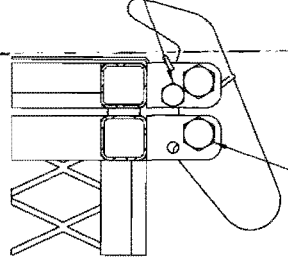
DETAIL A D8-2
D6-2

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN



DETAIL B D4-2

D4032-041: AN3-16A BOLT
MS21042L3 NUT
D4032-043: AN3-20A BOLT
MS21042L3 NUT

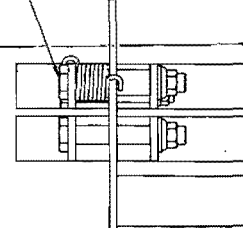


SECTION C-C B5-2
B7-2

D4032-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4032-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

AN5-17A BOLT
NAS1149F0563P WASHER
MS21042L5 NUT



D2530 WELDMENT
REF

VIEW F-F C3-3

D3953-17 GAS SPRING SPACER

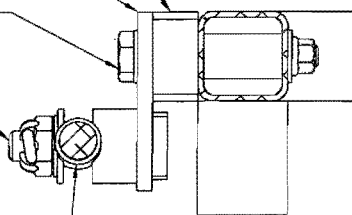
D3953-21 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2



D3953-17 GAS SPRING SPACER

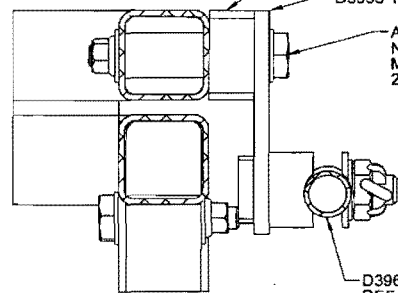
D3953-19 GAS SPRING BRACKET

AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2



RELEASED
10-08-12-9

DESIGN	AUS	DART AEROSPACE LTD	
DRAWN	5	HAWKESBURY, ONTARIO, CANADA	
CHECKED	20	DRAWING NO.	REV. D
MFG. APPR.	JFS	D4032	SHEET 3 OF 3
APPROVED	JND	TITLE	SCALE
DE APPR.	#	SHORT BASKET ASSY (350)	NTS
DATE	10.07.23	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries